

Date: Tuesday, 09/06/2009 7:50:02 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 48426	
Estimate Number : 10451	
P.O. Number :	Part Number : D33381
This Issue : 09/06/2009 S.O. No. :	Drawing Number : D3338 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 33248	Material :
Written By : <i>JP 09.06.09</i>	Due Date : 16/06/2009 Qty: 20 Um: Each
Checked & Approved By :	
Comment : Est:A 05.02.09 New issue KJ/JLM	

Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total : 1.4343 f(s)
 Lug Extrusion
 (D2423) Batch: *B43722*

JP 09/06/09

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut D2423 Extrusion: 0.82" Long

JP 09/06/09

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1- Check for extrusion defects while loading into the machine
 2- Machine as per Folio FA506 and Dwg D3338
 3- Tumble and Deburr
 Identify as D3338-1

JP 09/06/09

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JP 09/06/09

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JP 09.06.10

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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

ell

09-06-10

(X20)

7.0	POWDER COATING	POWDER COATING
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1111472

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 7:50am

OVEN TEMPERATURE: 320°F

FINISH TIME: 8:20am

ell

09-06-10

(X20)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

FZ

09/06/10

(20)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 4/68

9/6/10

(20)

59

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/06/11

Job Completion

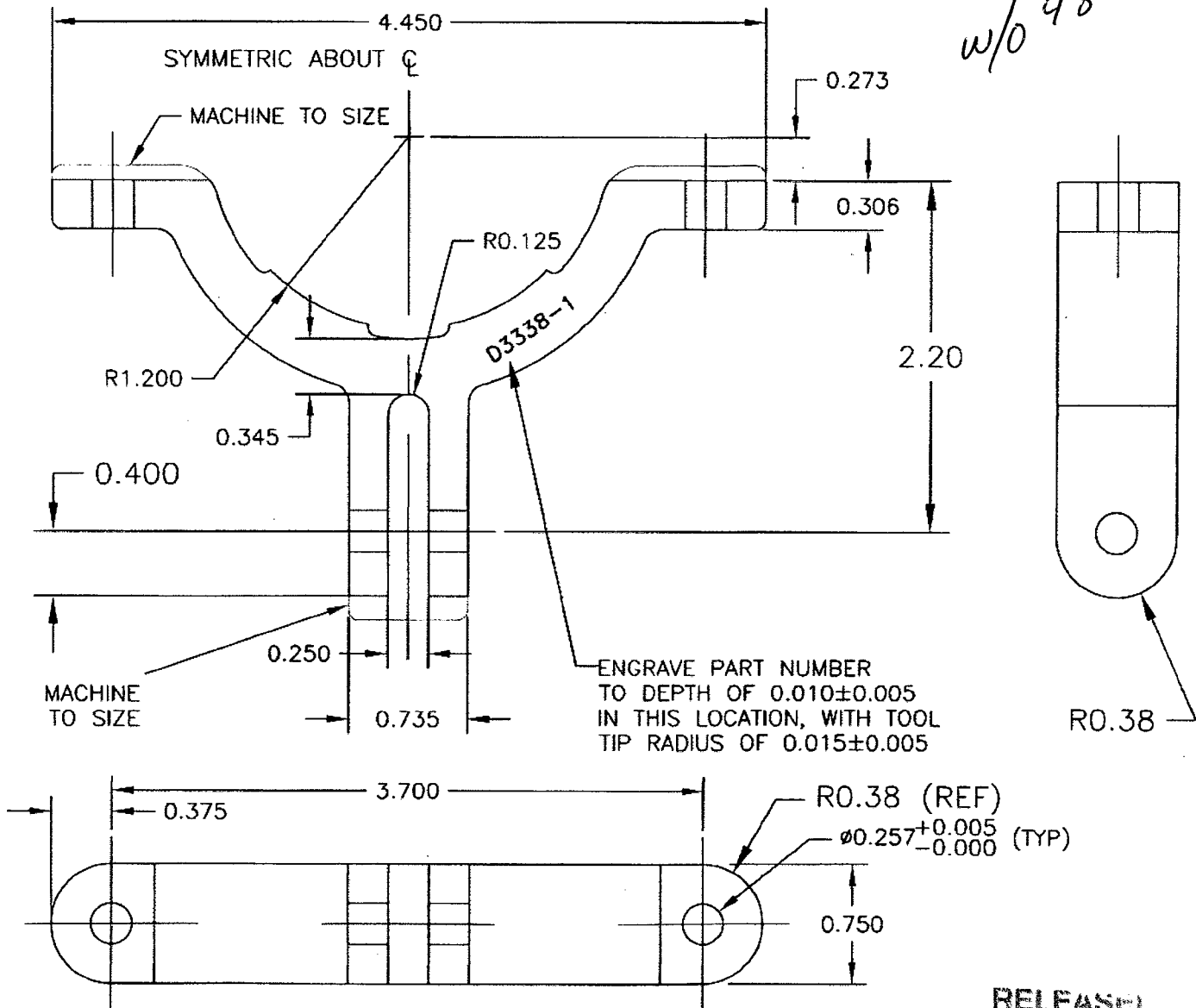


MF

09-06-10

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3338	REV. A SHEET 1 OF 1
DATE 04.11.03		TITLE MOUNTING LUG	SCALE 1:1
A	04.11.03	NEW ISSUE	

**D3338-1 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASE

04.12.16

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